

Date: Wednesday, 19/11/2008 2:18:03 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE ASSEMBLY
Job Number	: 43556B	Part Number	: D2282043
Estimate Number	: 11180	Drawing Number	: D2282 REV E
P.O. Number	:	Project Number	: N/A
This Issue	: 19/11/2008	Drawing Revision	: E
Prsht Rev.	: NC	Material	:
First Issue	: / /	Due Date	: 05/01/2009
Previous Run	: 43401B	Qty:	50
Written By	:	Um:	Each
Checked & Approved By	: <u>JLD 08.11.19</u>		
Comment	: Est Rev:A	Removed from 9 Digit	05-12-02 JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	<u>D2281</u>	Jack Saddle
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2281 Saddle 20110101-50x.

SP 09.03.2

2.0	<u>D2282</u>	Tube
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2282-7 tube B201101-20x.

SP 09.03.2

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per D2282-043 Saddle Assembly

M 108775

50x

A/R ER316L SS Filling Rod M 106115Dwg Rev: E

SP 09.03.04

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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50x

Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush, take all welding marks out and deburr holes

M-1 09/04/20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 19/11/2008 2:18:03 PM
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Process Sheet

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Drawing Name: SADDLE ASSEMBLY

Job Number: 43556B

Part Number: D2282043

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC9

VISUAL WELDING INSPECTION



LPL 09-04-20

Comment: VISUAL WELDING INSPECTION

6.0 QC5

INSPECT WORK TO CURRENT STEP



cont'd

Comment: INSPECT WORK TO CURRENT STEP

7.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-tumble

R 9-04-22

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S8 09/04/22

50

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *SA*

S8 09/04/22

50

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MF 09-04-22

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

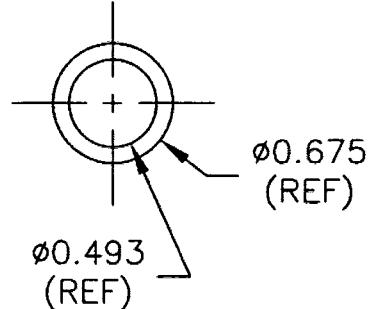
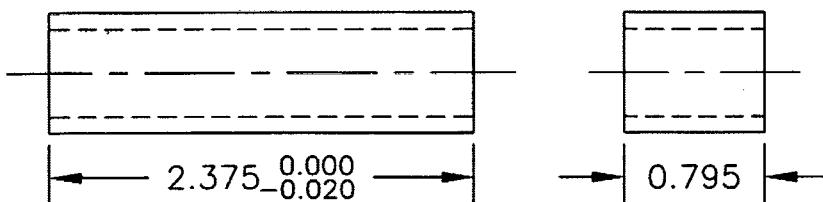
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN BW	DRAWN BY <i>PB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>100%</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

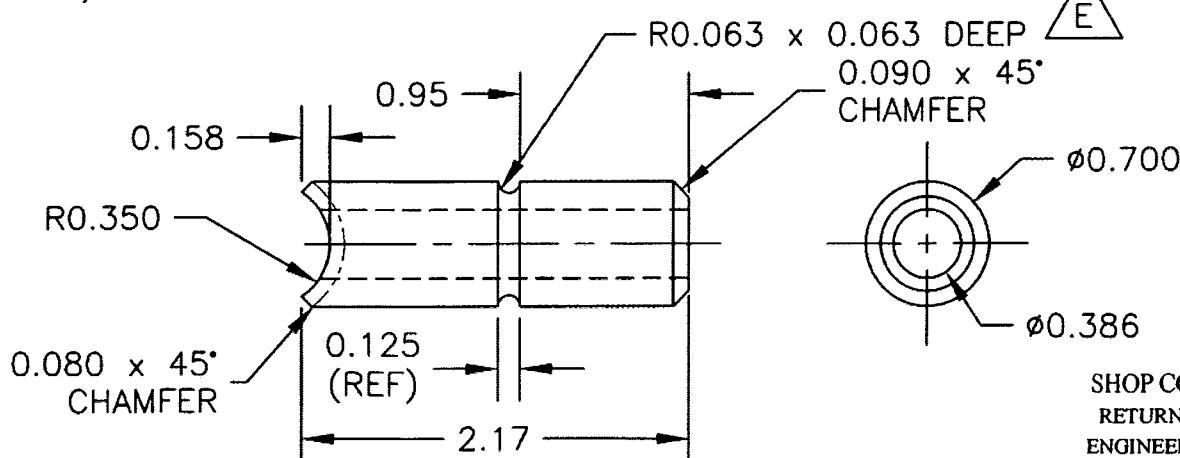
RELEASED
BS/09/16

**D2282-3**

D **D2282-7**

D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D **D2282-5**

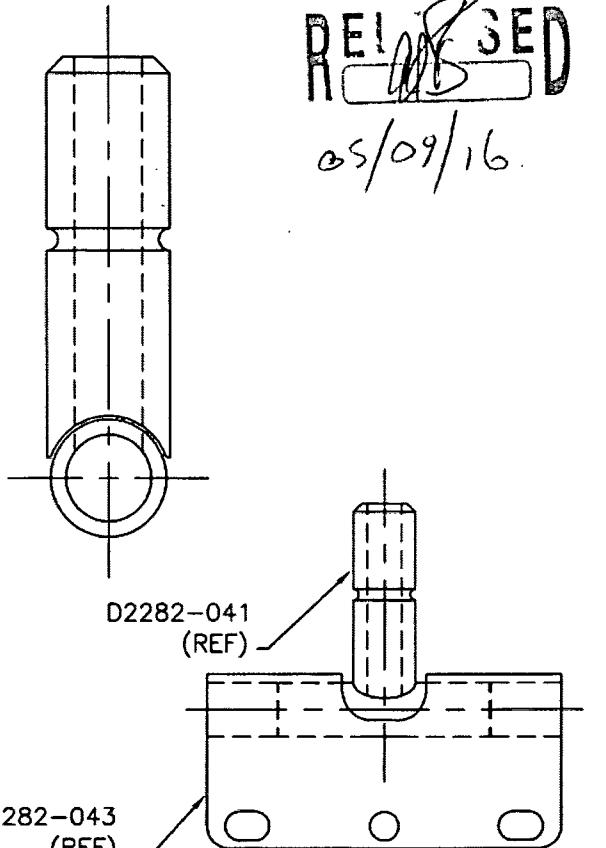
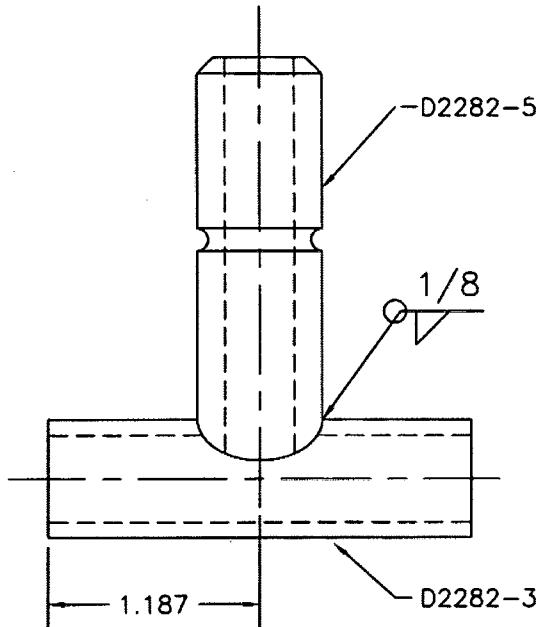
D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

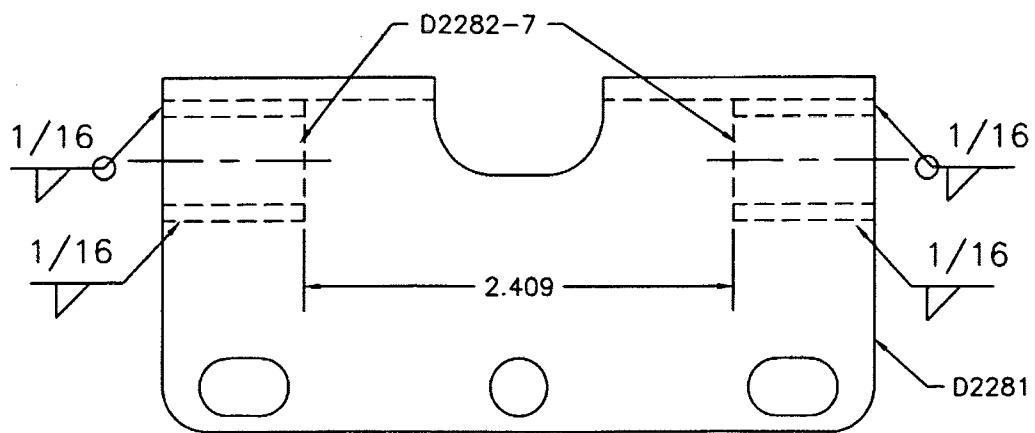
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NO. *45556B*
E

DART

DESIGN BW	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>AB</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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